

Date: Thursday, 6/21/2007 2:28:39 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
Job Number : 33042
Estimate Number : 10533
P.O. Number : NIA
This Issue : 6/21/2007 S.O. No. : NIA
Prsht Rev. : NC
First Issue : NIA Type : MACHINED PARTS
Previous Run : 32167
Written By :
Checked & Approved By : [Signature]
Comment : Est: 1 As Per RevE 06-01-27 JLM

Drawing Name : SADDLE FITTING, AFT (OUTBOARD/INBOARD)
Part Number : D2573
Drawing Number : D2573 REV E
Project Number : N/A
Drawing Revision : E
Material : NIA
Due Date : 7/11/2007 Qty: 12 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)
7075-T7351 8.25X7.75X2.5
Make from D6101-007 billet for D2573
Ensure that grain is along 7.75" length
Batch No: 1325353

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
Program Batch No. SD Double check by: J.F.

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
4-Deburr and remove all machining marks
5-Tumble to remove sharp edges.

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
Machine keyway as per dwg D2573 & D2574

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☒ DQA: ☒ Date: 11/16/23

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:28:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, AFT (OUTBOARD/INBOARD)

Job Number: 33042

Part Number: D2573

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.F. 07/07/16

(14)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

JSD 07-07-16

(12)

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat GREEN SANDTEX (Ref: 4.3.5.1) as per QSI 005 4.3

m 18144

MBL 07-07-16 12

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

7/7/17 SD

(12x)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

2/7/17 SD

(12x)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07.07.17

Job Completion



u 07.07.17

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33042
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.459	0.441	0.439	0.438		
B	1.745	1.755		1.757	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.506	3.506		
D	1.745	1.755		1.750	1.750	1.756	1.750		
E	7.990	8.010		8.001	8.000	7.998	7.999		
F	0.490	0.510		.496	0.504	0.505	0.504		
G	0.257	0.262	DT8683	.257	0.258	0.258	0.258		
H	0.375	0.380	DT8684	.376	0.377	0.377	0.377		
I	0.490	0.510		.503	0.503	0.503	0.504		
J	1.174	1.184		1.179	1.178	1.178	1.178		
K	0.558	0.578		.568	0.571	0.571	0.571		
L	1.174	1.184		1.179	1.178	1.178	1.178		
M	1.365	1.375		1.370	1.368	1.368	1.368		
N	2.495	2.505		2.498	2.500	2.506	2.498		
O	4.119	4.129		4.124	4.121	4.121	4.122		
P	0.115	0.135		.124	0.123	0.123	0.123		
Q	0.115	0.135		.134	0.135	0.135	0.135		
R	0.240	0.260		.230	0.249	0.249	0.248		
S	0.115	0.135		.123	0.123	0.120	0.124		
T	0.178	0.198		.188	0.188	0.188	0.188		
U	3.210	3.250		3.231	3.230	3.230	3.230		
V	0.230	0.250		.242	0.242	0.241	0.243		
W	0.115	0.135		.127	0.121	0.123	0.126		
X	0.308	0.313		.310	0.310	0.310	0.310		
Y	0.760	0.765		.767	0.761	0.761	0.761		
Z	0.352	0.372		.364	0.358	0.361	0.362		
AA	0.470	0.530		.500	0.506	0.500	0.500		
AB	0.615	0.635		.635	0.620	0.634	0.625		
AC	0.053	0.073		.063	0.063	0.063	0.063		
AD	0.240	0.260		.248	0.246	0.245	0.247		
AE	1.500	1.520		1.511	1.511	1.512	1.509		
AF	0.115	0.135		.125	0.132	0.132	0.132		
AG	0.240	0.280		.255	0.255	0.260	0.265		
AH	0.240	0.260		.252	0.250	0.253	0.253		
AI	2.000	2.020		2.002	2.001	2.003	2.006		
AJ	0.023	0.043		.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	SD/ame
Date:	07/07/13

Audited by:	J.F.
Date:	07/07/06

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	33042
Description: Saddle, Aft Outboard	Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.4385	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.501	3.500	3.500	3.500		
D	1.745	1.755		1.749	1.750	1.751	1.745		
E	7.990	8.010		8.003	8.002	8.003	8.003		
F	0.490	0.510		.494	.498	.496	.500		
G	0.257	0.262	DT8683	0.258	0.258	.258	.258		
H	0.375	0.380	DT8684	0.377	0.377	.377	.377		
I	0.490	0.510		0.502	0.502	.504	.456		
J	1.174	1.184		1.178	1.178	1.179	1.179		
K	0.558	0.578		0.569	0.570	.568	.570		
L	1.174	1.184		1.178	1.178	1.178	1.179		
M	1.365	1.375		1.369	1.369	1.370	1.370		
N	2.495	2.505		2.506	2.506	2.500	2.501		
O	4.119	4.129		4.121	4.121	4.123	4.123		
P	0.115	0.135		0.123	0.123	.124	.124		
Q	0.115	0.135		0.135	0.135	.135	.135		
R	0.240	0.260		0.249	0.249	.251	.250		
S	0.115	0.135		0.120	0.121	.124	.122		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	3.210	3.250		3.236	3.236	3.232	3.232		
V	0.230	0.250		0.240	0.240	.245	.245		
W	0.115	0.135		0.123	0.123	.123	.123		
X	0.308	0.313		.307	.310	.310	.310		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.364	.365	.364	.364		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		.625	.621	.625	.620		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.248	.252	.251		
AE	1.500	1.520		1.511	1.511	1.511	1.512		
AF	0.115	0.135		0.135	0.132	.130	.131		
AG	0.240	0.280		0.255	0.257	.265	.265		
AH	0.240	0.260		0.250	0.250	.253	.252		
AI	2.000	2.020		2.001	2.002	2.002	2.003		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	9ml
Date:	07/07/11 3

Audited by:	J.F. 07/07/16
Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 72072
Description: Saddle, Aft Outboard		Part Number: D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443	DT8682						
B	1.745	1.755							
C	3.495	3.505							
D	1.745	1.755							
E	7.990	8.010							
F	0.490	0.510							
G	0.257	0.262	DT8683						
H	0.375	0.380	DT8684						
I	0.490	0.510							
J	1.174	1.184							
K	0.558	0.578							
L	1.174	1.184							
M	1.365	1.375							
N	2.495	2.505							
O	4.119	4.129							
P	0.115	0.135							
Q	0.115	0.135							
R	0.240	0.260							
S	0.115	0.135							
T	0.178	0.198							
U	3.210	3.250							
V	0.230	0.250							
W	0.115	0.135							
X	0.308	0.313							
Y	0.760	0.765							
Z	0.352	0.372							
AA	0.470	0.530							
AB	0.615	0.635							
AC	0.053	0.073							
AD	0.240	0.260							
AE	1.500	1.520		1.510	1.511				
AF	0.115	0.135							
AG	0.240	0.280							
AH	0.240	0.260							
AI	2.000	2.020		2.002	2.002				
AJ	0.023	0.043							
Accept/Reject									

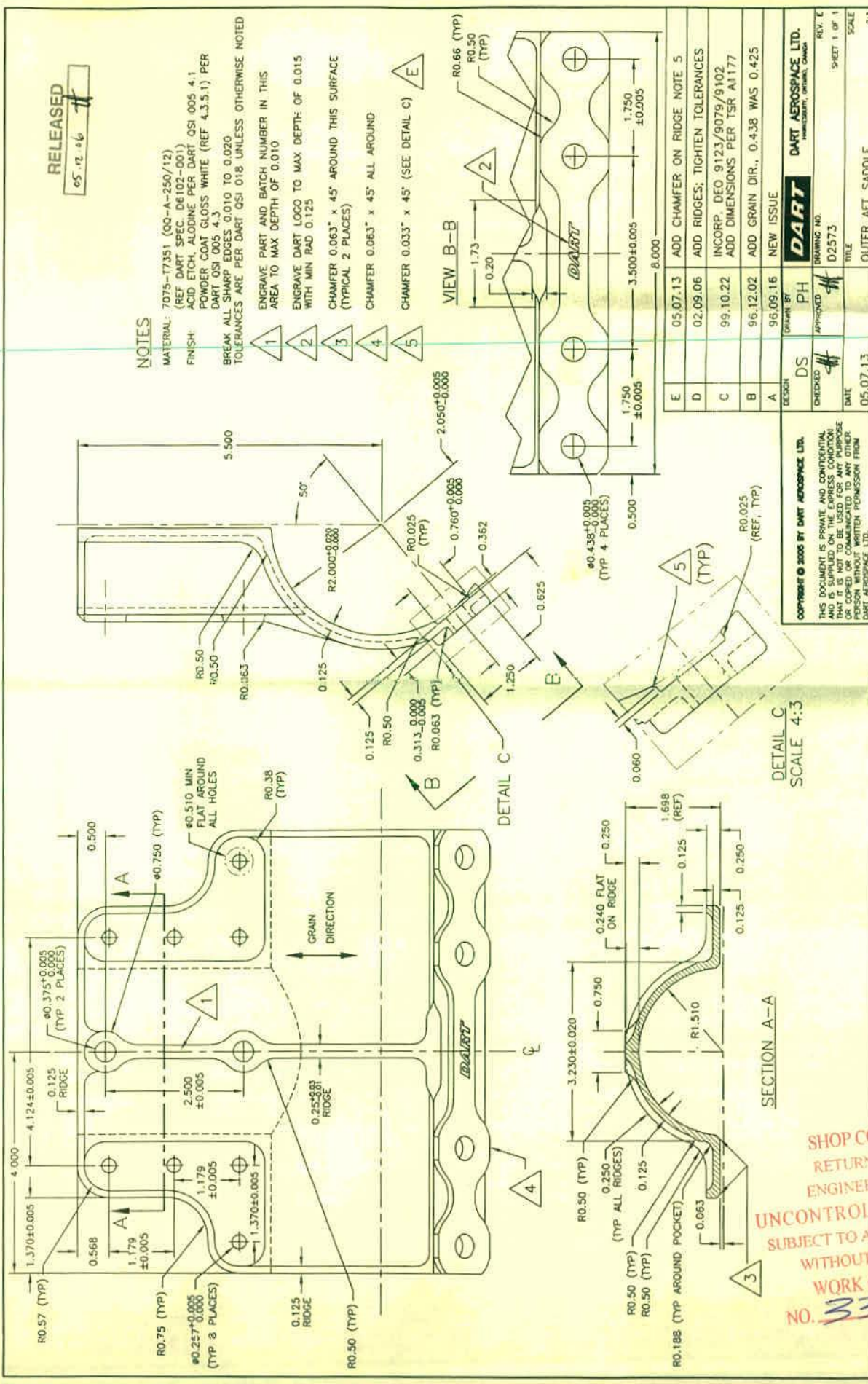
Measured by: SP
Date: 21.01.16

Audited by: J.F.
Date: 07/07/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

05.12.16



NOTES

- MATERIAL: 7075-T7351 (Q0-A-250/12)
(REF DART SPEC. DE102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 - 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
 - 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 - 4 CHAMFER 0.063" x 45° ALL AROUND
 - 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

DETAIL C
SCALE 4:3

SECTION A-A

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33042

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PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE LTD.

DESIGN DS PH
CHECKED APPROVED
DATE 05.07.13
DRAWING NO. D2573
SHEET 1 OF 1
SCALE 2:3
TITLE OUTER AFT SADDLE
REV. E
DART AEROSPACE LTD.
HAMMERSLEY, DARTFORD, ENGLAND

DART AEROSPACE LTD		Work Order:	33042
Description: Saddle, Aft Outboard		Part Number:	D2573
Inspection Dwg: D2573 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2573 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.002	8.002	8.002		
F	0.490	0.510		.496	.498	.500	.497		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.502	.505	.500	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.571	.569	.570		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.365	1.375		1.370	1.370	1.370	1.370		
N	2.495	2.505		2.501	2.499	2.499	2.498		
O	4.119	4.129		4.123	4.124	4.124	4.124		
P	0.115	0.135		.123	.124	.123	.122		
Q	0.115	0.135		.135	.135	.135	.133		
R	0.240	0.260		.249	.250	.249	.250		
S	0.115	0.135		.122	.124	.125	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	3.210	3.250		3.232	3.232	3.232	3.232		
V	0.230	0.250		.244	.242	.243	.242		
W	0.115	0.135		.124	.122	.124	.124		
X	0.308	0.313		.311	.310	.310	.310		
Y	0.760	0.765		.762	.763	.763	.763		
Z	0.352	0.372		.363	.364	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.632	.627	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.249	.249	.249		
AE	1.500	1.520		1.511	1.511	1.511	1.510		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.253	.260	.260	.260		
AH	0.240	0.260		.250	.252	.252	.252		
AI	2.000	2.020		2.002	2.002	2.003	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SD
Date:	01.07.15

Audited by:	J.F.
Date:	07/07/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.26	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

AEROSPACE L D

Work Order:

33042

Part Number:

D2513

This drawing is a preliminary sheet drawing D2513 Rev. 0 and Record only.

Recorded Actual Dimensions

Rev.	Part No.	1	2
1	439	439	
2	1.750	1.750	
3	3.000	3.000	
4	1.750	1.750	
5	8.000	8.000	
6	4.995	5.000	
7	2.58	2.58	
8	3.76	3.76	
9	5.06	5.04	
10	1.175	1.175	
11	5.71	5.71	
12	1.175	1.175	
13	1.370	1.370	
14	2.498	2.498	
15	4.124	4.124	
16	.123	.123	
17	.135	.135	
18	.250	.251	
19	.123	.123	
20	.188	.188	
21	3.232	3.232	
22	2.45	2.45	
23	.124	.124	
24	.310	.310	
25	.763	.763	
26	.366	.365	
27	.500	.500	
28	.627	.628	
29	.063	.063	
30	.251	.251	
31	1.510	1.511	
32	.135	.135	
33	.260	.260	
34	.251	.251	
35	2.002	2.002	
36	.033	.033	

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SA
27-01-16

Date

JF-07

Date	Change	Revised by
9-86	New Issue	RF
9-86	Re-format. Added Rev. D	KJ
9-86	Re-format. Added DT8682, DT8683, DT8684	KJ
15-86	Added dimension A1	KJRF
12-86	Added dimension A1	KJULM

